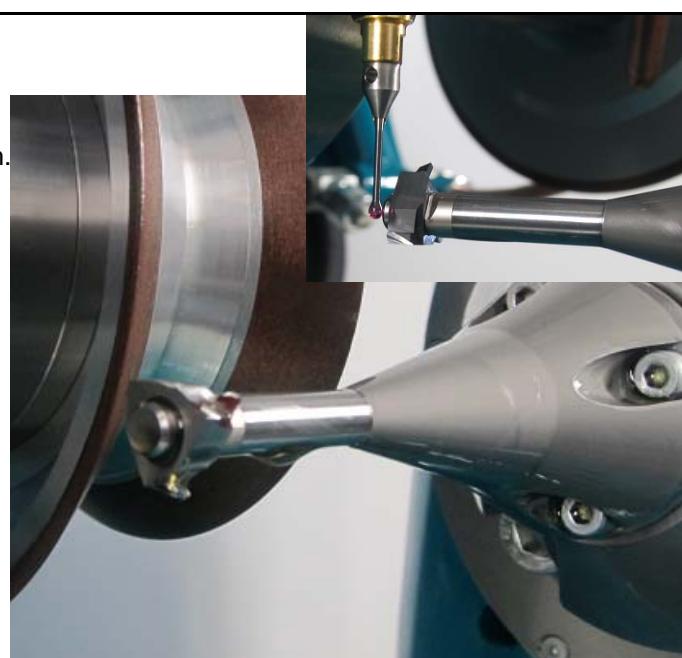


Insert: Triangular

A08-200

Wheelholder L=120mm, for bore 20. Side-triangle is a pendeling method. TTC for hole-diameter 3.65 and 5.13 mm. Finishing and polishing should be foreseen.



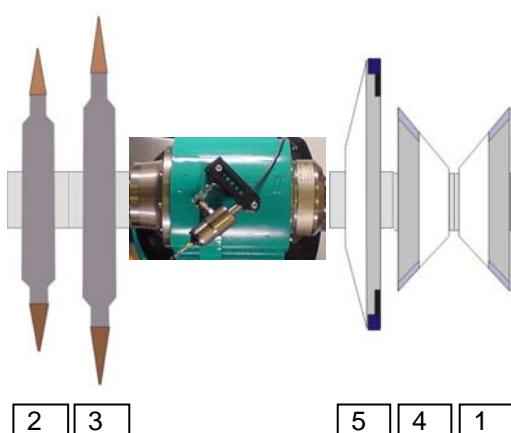
1. Cycletime for Production

Workpiece:	Ref.-Dia.13.00, width 4.76, clearance 7° Material CARBIDE					
Operations	Probe	Prf Rough	Prf Pgrd	Prf fin	Chipbreaker	Side-triangle
Feed [mm/Min]	2000	120	100	90	100	10000
Power [kW]		2	1	1	1	1
Cutting speed [m/s]		20	22	22	24	24
Used wheels		1	2	3	4	5
Grinding time [s]	6	411	59	59	58	13
Total cycle time	10 Min 5					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12V9 Ø125 D64
2	14EE1 Ø200 D76V20°
3	14EE1 Ø250 D76V20°
4	12V9 Ø125 D64
5	12C9 Ø250 D64



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsible engineer: KCM: 13.3.12

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